

FIG. 3

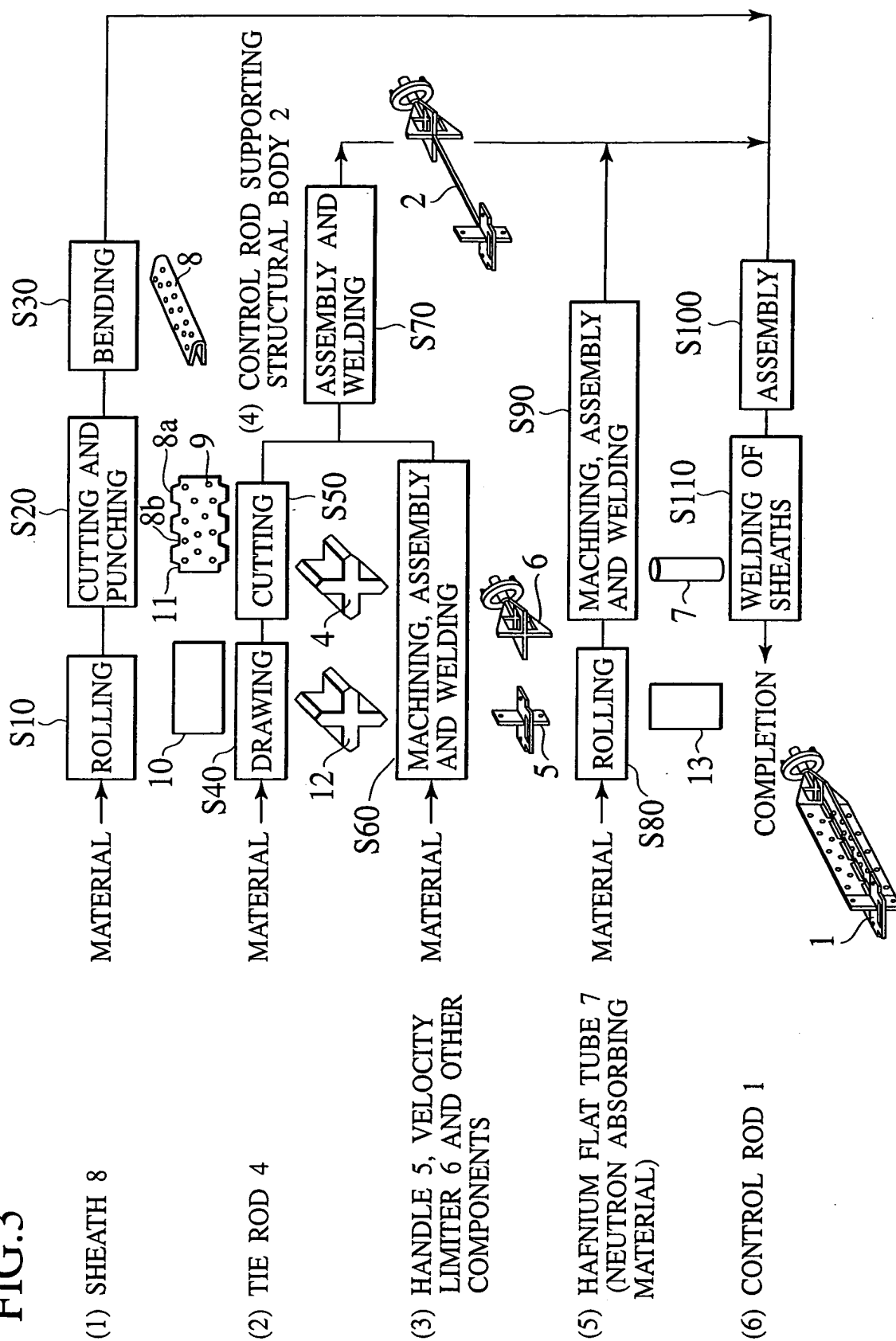


FIG.6

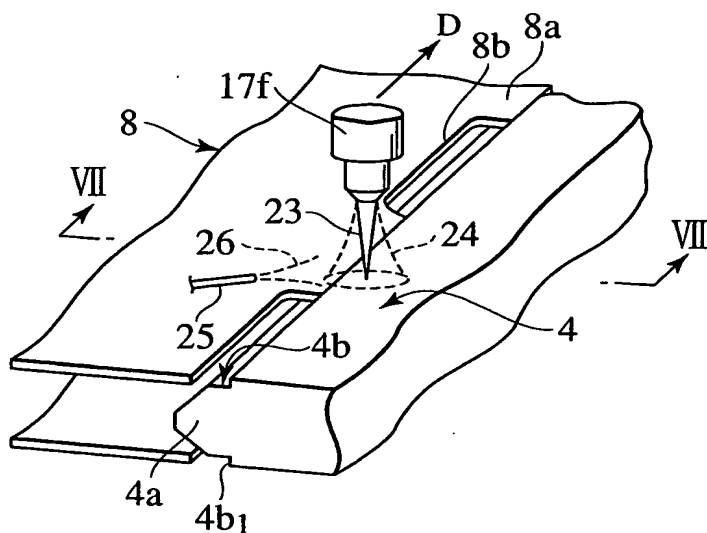


FIG.7

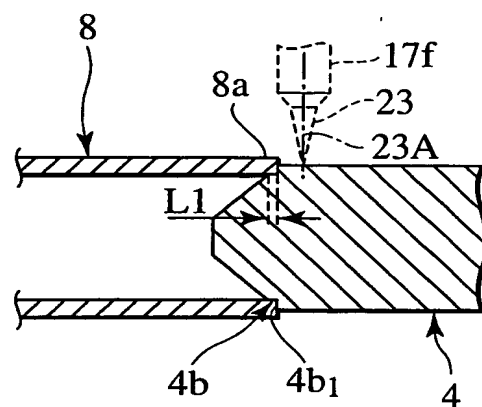


FIG.8

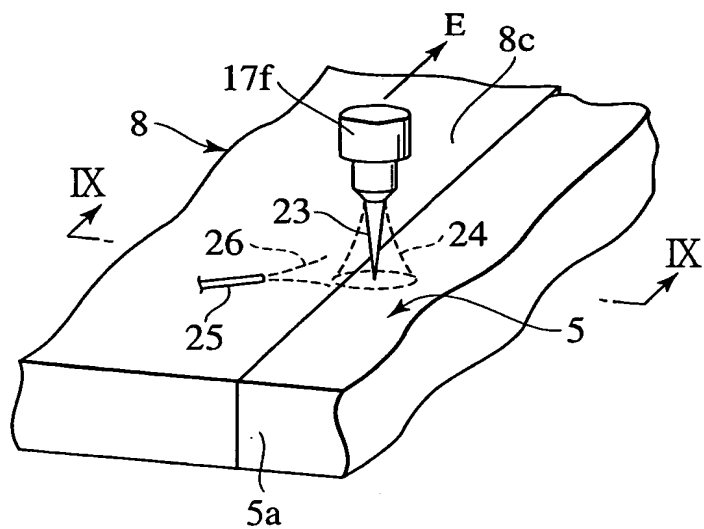


FIG.9

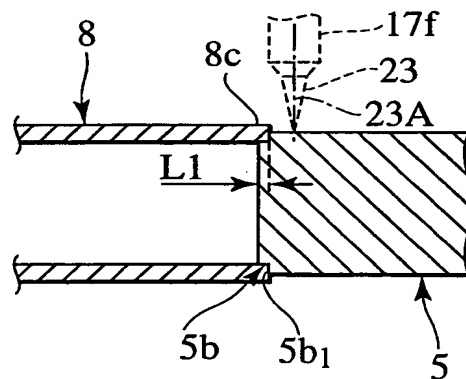


FIG.10

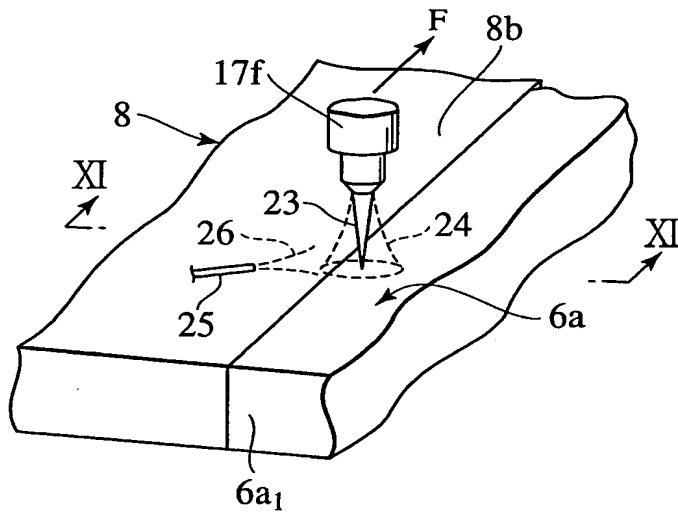


FIG.11

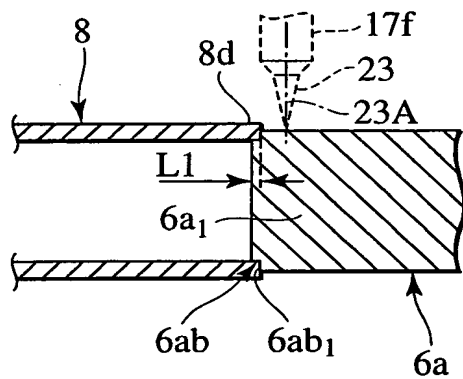


FIG.12

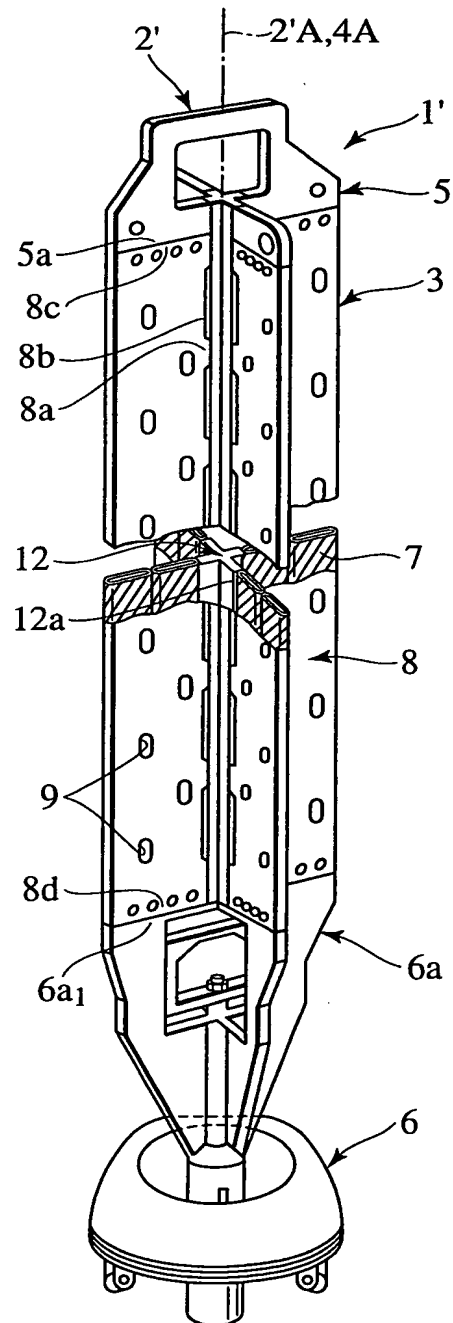
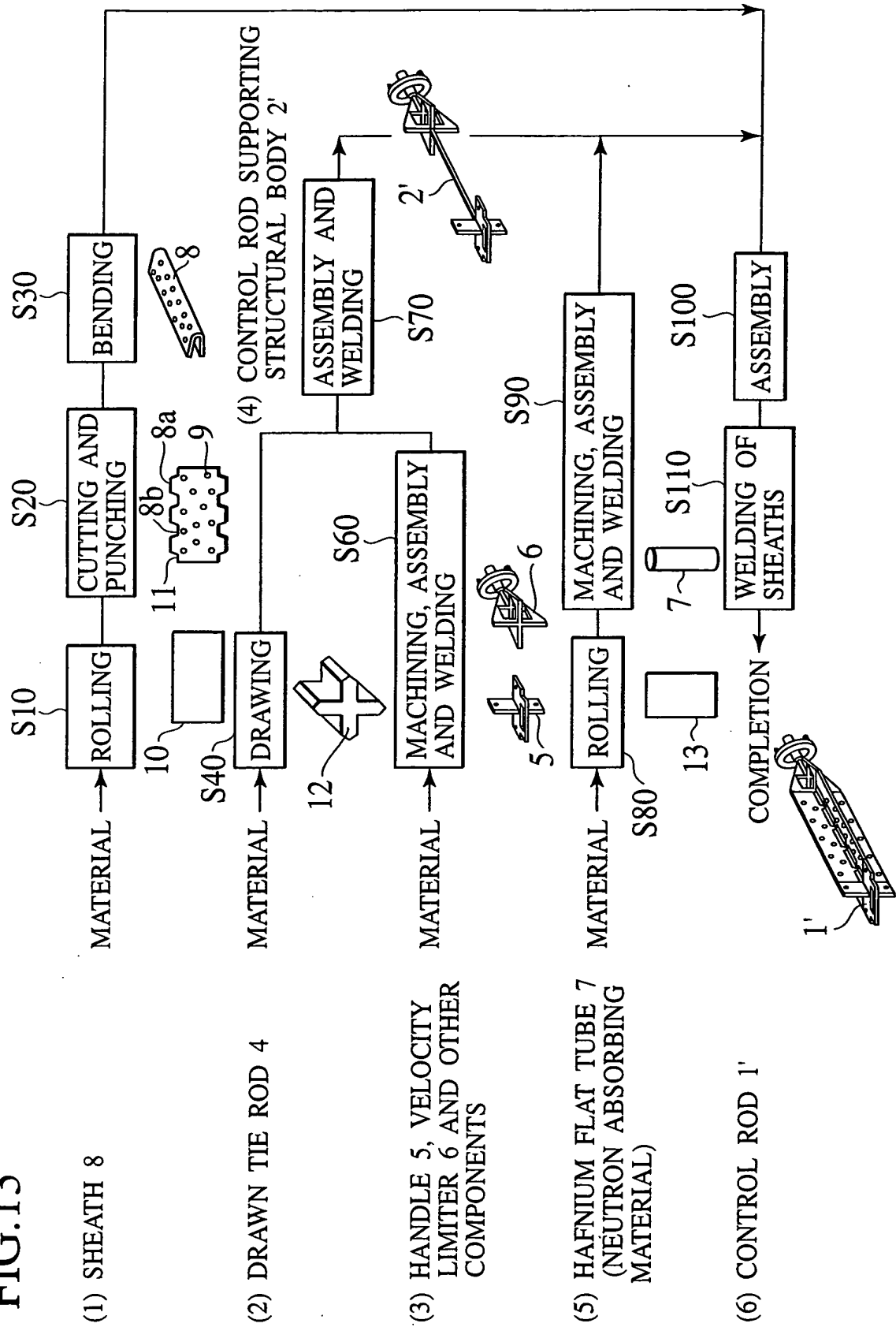


FIG.13



MODE OF YAG LASER OUTPUT	CONTINUOUS WAVE
WELDING LENGTH (mm)	30
NUMBER OF WELDING PASSES	1
TRAILER GAS, SHIELDING GAS	N ₂
DIAMETER (mm) OF WELDING ROD 30	0.6
GAP (mm) BETWEEN TIE ROD 4 AND SHEATH 8	0~0.3
DISTANCE (mm) FROM EDGE OF SHEATH PROJECTION 8A TO BEAM CENTRAL AXIS 23A (WHEN DIRECTION TOWARD SHEATH 8 IS POSITIVE, AND DIRECTION TOWARD AXIS CENTER 4A OF TIE ROD 4 IS NEGATIVE)	-0.5~0.5
HEAT INPUT (kJ/cm)	0.69~1.63
CONVERGING DIAMETER (mm)	0.57~0.98
SUPPLY (g/m) OF CONTROL ROD 30 FOR ONE METER OF WELDING	1.25~4.06
OVERLAP (mm) OF TIE ROD 4 WITH SHEATH 8	0.2~0.8

FIG.17

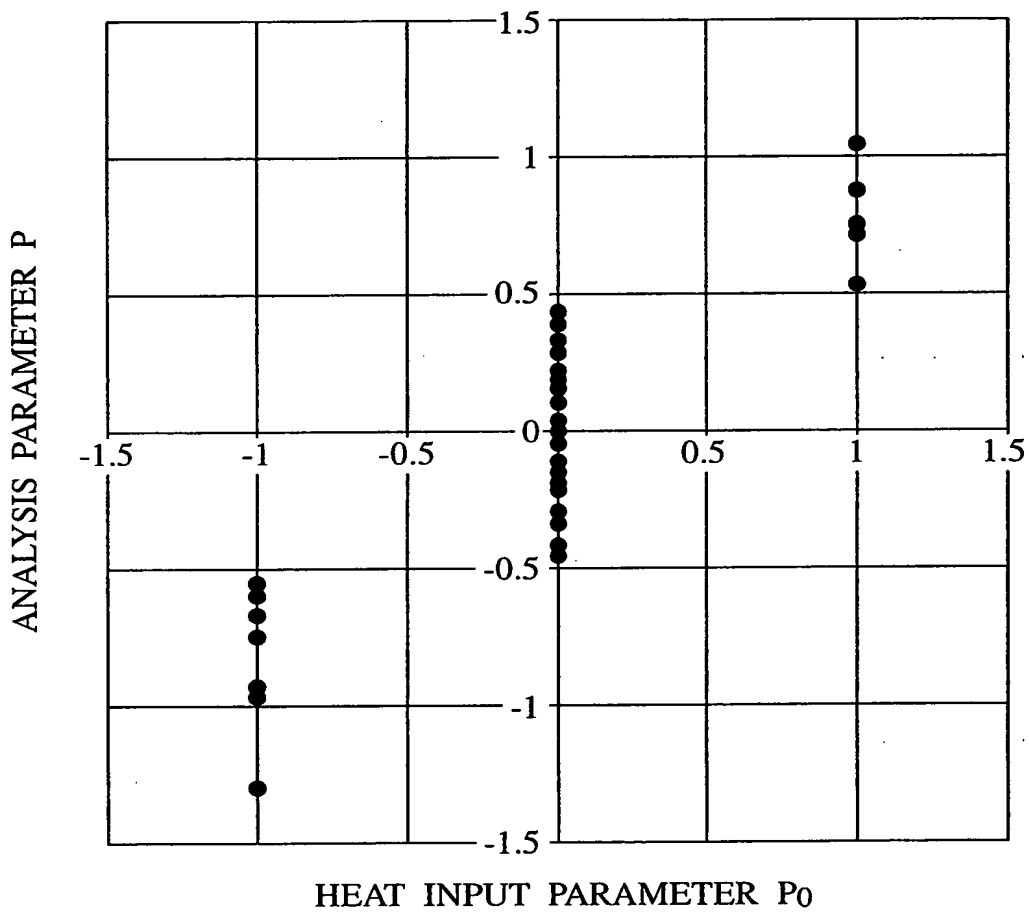


FIG.21

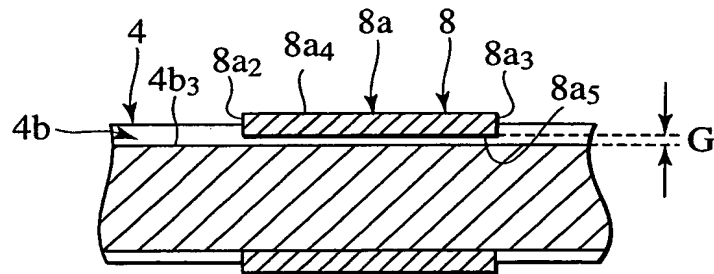


FIG.22

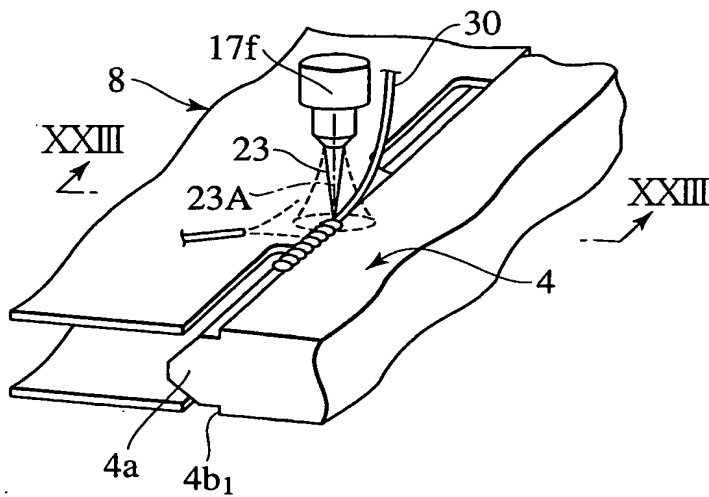


FIG.23

